

# Work Order ID 69761

Wednesday, May 18, 2011 1:46:49 PM



Page 1

Item ID: D3443-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tubing

Start Date: 5/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 11/05/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3443	Rev C								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	1-Cut blank 5.97 " long 2-Deburr								
110		0.00							
	CONVENTIONAL MILLING MACHINE								
Mill Conv	Memo	0.00							
Conventional Milling Machine	1- Mill to lenght and drill holes (one side only)as per dwg D3443 2-Deburr as per dwg D3443								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

11/05/19

6

11/05/19

6

11/05/19

6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

# Work Order ID 69761

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Page 2

Item ID: D3443-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Tubing

Start Date: 5/18/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/25/2011 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		20 11-5-19		6			
140  Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A 22</u>  Memo *****STOCK IN LARGE FAB*****	0.00  0.00							
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

CP 11-05-24

11/5/24 78

11-05-24  
(6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

• **NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 18, 2011 1:46:46 PM

Page 1

Work Order ID: 69761



Parent Item: D3443-5



Parent Item Name: Tubing

Start Date: 5/18/2011

Required Date: 5/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: A 05.11.14 New issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No			100	f	32.8400	0.495	3.126316			



304 ss round tube .750 x .120w



Location

Loc Qty

Loc Code

MAT017

32.84

114706

32.84

3.4 ~~10~~ 4/05/18

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

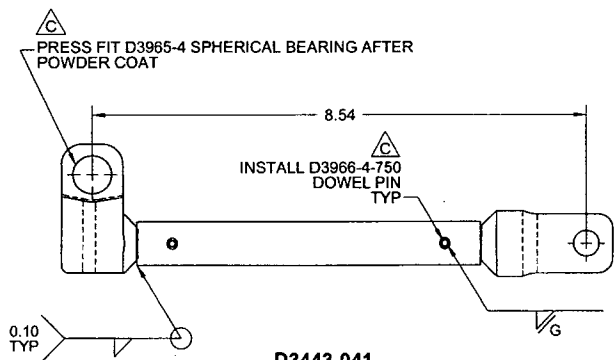
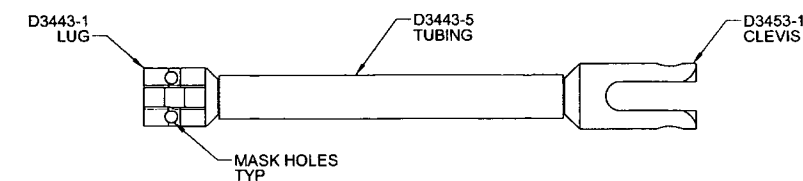
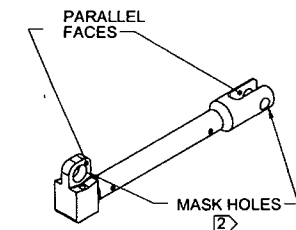
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

\* **NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D3443-041**

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.33 lbs
  - 8) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

CL11105118  
WID: 69761

**RELEASED**  
09/08/25 MP

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.561 WAS 0.451 (ZN C1-3); R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3443	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STRUT WELDMENT ASSEMBLY NTS	
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CONSIDERED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

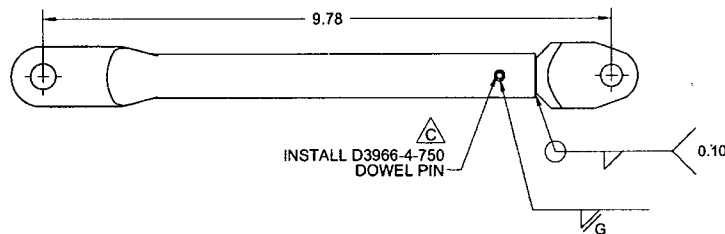
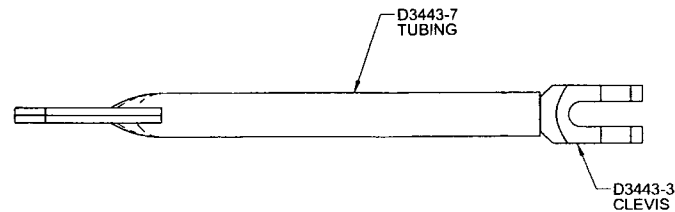
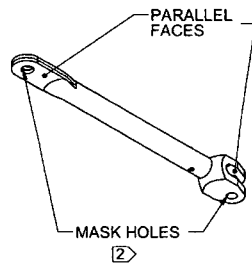
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

• **NOTE:** Date & initial all entries



ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



**D3443-043**

**RELEASED**  
09/06/25/14

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

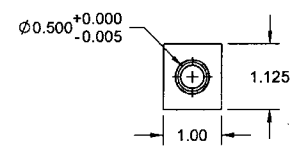
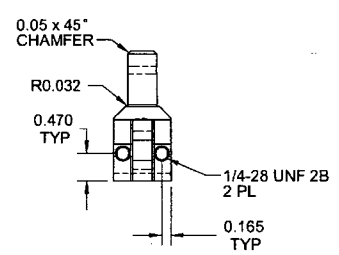
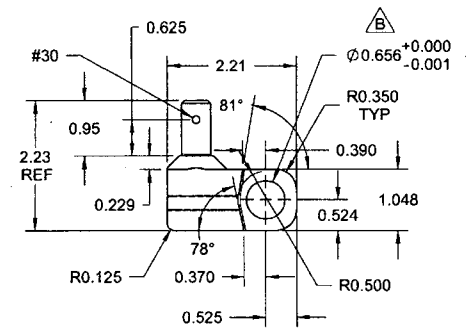
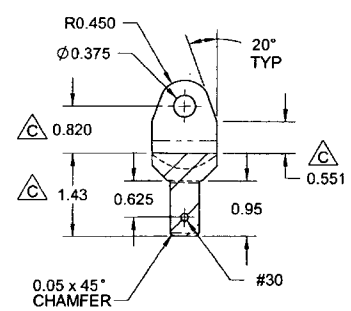
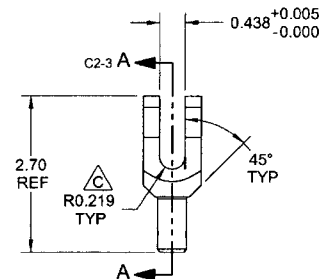
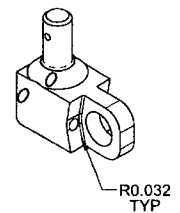
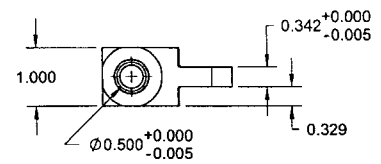
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

\* NOTE: Date & initial all entries

8 7 6 5 4 3 2 1






**D3443-1 LUG**

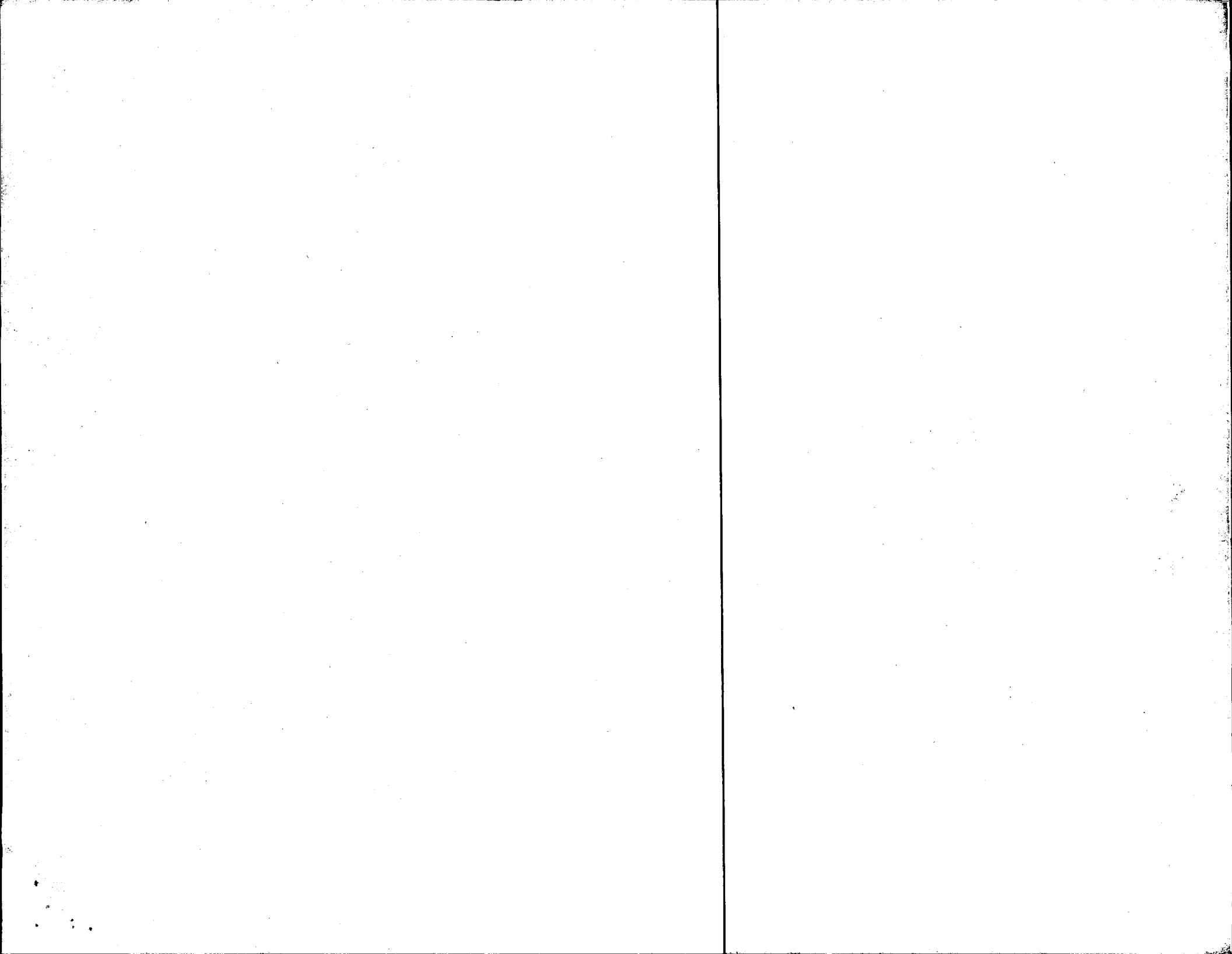
**D3443-3 CLEVIS**

**RELEASED**  
09/08/25/14

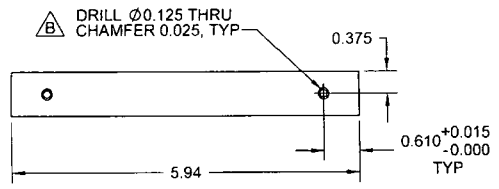
- NOTES:**  
 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)  
 D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: D3443-1 = 0.50 lbs  
 D3443-3 = 0.35 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3443</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>STRUT WELDMENT ASSEMBLY NTS</b>	
DATE	<b>09.06.25</b>	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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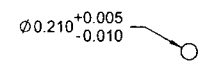
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562  
547

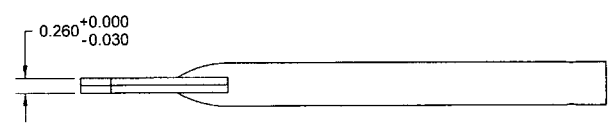


**D3443-5 TUBING**

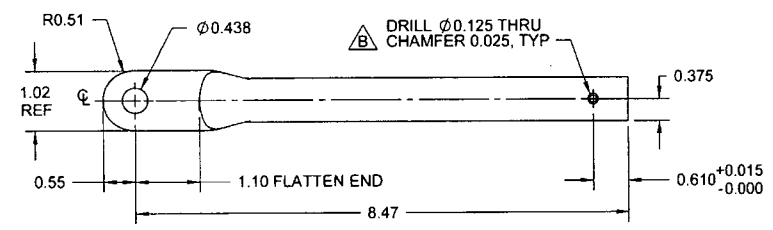


**D3443-9 PIN**

- D3443-9 NOTES:**  
 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: N/A







**D3443-7 TUBING**



- D3443-5/7 NOTES:**  
 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: D3443-5 = 0.41 lbs  
 D3443-7 = 0.62 lbs

# 69761

RELEASED  
01/25/10



DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD	Work Order: 69761
Description: Tubing	Part Number: D3443-5
Inspection Dwg: D3443, Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X

[illegible]

Measured by: 	Audited by: 	Prototype Approval:
Date: 11/05/19	Date: 11-5-19	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

